

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000416**Date Inspected:** 07-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

Witness: **Procedure Qualification Record**
Welding **NDT**

Welder Qualification **Fracture Critical**
Mechanical Testing, describe:Macro Etching

Index Lot #: B22-030-07**Witness Lot #:** B75-077-07**Bridge No:** 34-0006**Component:** Bid item 52,55 Tower & Girder**Welder:** Zhuhai Ping**ID #:** na**Joint Description:** T Fillet

N/A

WPS ID #: PWPS-B-T-3111

N/A

Base Metal: A709 Gr HPS485WT2/Z

N/A

PQR ID #: HP20077157-2

N/A

Thickness: 90mm

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS-A5.1/E-7018-1

N/A

Positions: 1F

N/A

Backing Material: N/A

N/A

CWI: Huang Wei

N/A

Average Amps: 223 amps

N/A

AWS Code: AWS D1.5 (2002)

N/A

Average Volts: 23.9 volts

N/A

Applicable Sec: AWS 5.13

N/A

Travel Speed: 111.13 mm/min

N/A

Heat Input: 2.88 kj/in

N/A

Preheat: 190 degrees C

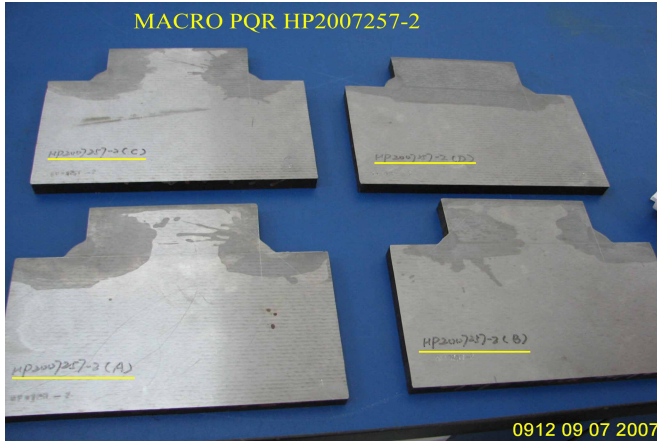
N/A

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe macro etching being performed for a fillet weld soundness test for Procedure Qualification Record (PQR)HP2007257-2. There were 4 specimens each marked with the with the PQR Number and each separately marked with the letters A, B, C and D. All specimens were accepted by ZPMC CWI Huang Wei and verified by the QA Inspector. The QA Inspector assigned Caltrans Lot Number B75-077-07.

WELDING WITNESS REPORT

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Summary of Conversations:

There were no relevant conversations.

Observed welding, testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco, Charlie

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer